



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.0112

Job Sheet 171186



Part No: 647.0112

Job Qty: 40 ea

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	2/17/18	2/17/18	0.00	0.00	Start Up Waterjet		DL 18/02/10
100	Waterjet	40 pcs	2/17/18	2/17/18	0.00	1.57	Waterjet1		DL 18/02/10
110	QC	40 pcs	2/17/18	2/17/18	0.00	0.00	QC2 Waterjet-1		DL 18/02/10
120	QC	40 pcs	2/17/18	2/17/18	0.00	0.00	QC8-1		38
130	Brake NC	40 pcs	2/17/18	2/17/18	0.00	1.79	Brake NC 1		DAB 38 FF
140	QC	40 pcs	2/17/18	2/17/18	0.00	0.00	QC5		38
150	SprayPaint	40 pcs	2/19/18	2/19/18	0.00	0.94	Spray Paint		17-02-22
160	QC	40 pcs	2/19/18	2/19/18	0.00	0.00	QC14		38
170	Packaging	40 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3-1		CK 106 FEB 23 2018
180	QC21-SA	40 Ea	2/19/18	2/19/18	0.00	0.00	QC21		18/02/23

Part Op 100 - 1-Cut as per Dwg
Descriptions: 130 - USE DT9834 FOR FORMING
150 - PRIME AS PER DWG NOTE 6 BATCH: 138798
170 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

DAB
21
9-80

FEB 23 2018

Job BOM

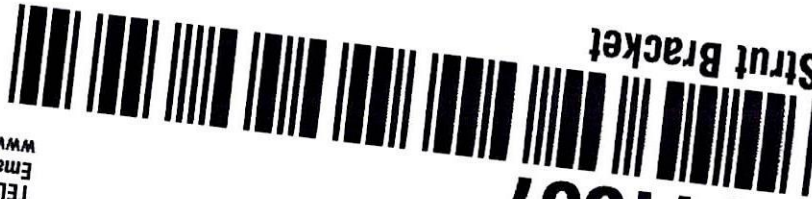
Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	1.3000 sf (.0325 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S14GA	1	64	0

DART
AEROSPACE

S041557



Strut Bracket

PART NO:
Original Serial #: S041557
Revision:
Operation:
Change No:

647.0112

Start up Operation
02/12/18
Job No: 171186

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CANADA
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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176		
2	Strut Bracket	0.191Inches + 0.005 - 0.001	0.196 0.190		
3	Strut Bracket	0.300Inches ± 0.030	0.330 0.270		
4	Strut Bracket	0.900Inches ± 0.030	0.930 0.870		
5	Strut Bracket	0.350Inches ± 0.010	0.360 0.340		
6	Strut Bracket	1.500Inches ± 0.030	1.530 1.470		
7	Strut Bracket	1.006Inches ± 0.030	1.036 0.976		
8	Strut Bracket	0.080Inches ± 0.010	0.090 0.070		

Plex 1/31/18 9:30 AM Dart.Gagnon.Michelle

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					